

Work Order ID 84001

84001

Page 1

May-01-12 10:37:19 AM

Item ID: D3041-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Clamp

Start Date: 01/05/2012 Start Qty: 30.00 ***30***

Cust Item ID:

Required Date: 15/05/2012 Req'd Qty: 30.00 ***30***

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/05/01 Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3041	Rev C								

100 BAND SAW 0.00

100

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut D2423 Extrusion: 1.250" Long

cut @ meter

110 HAAS CNC VERTICAL MACHINING #1 0.00

110

HAAS 1 *search*

Memo

0.00

HAAS CNC vertical machine #1

Check for cracks while loading into the machine

Machine as per Folio FA153 and Dwg D3041

DWG REV: _____

FOLIO REV: _____

PO 16878

12-05-2

issue P10 to meter

machine as per dwg D3041 REV.C

120 QC2-Inspect parts off machine FAI/FAIB 0.00

120

QC *rec'd*

Memo

0.00

Quality Control

*rec'd + inspect for transit damage
attached c/c to W/O*

Conf/27 35

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130 QC Inspect parts - second check

0.00

130

QC Memo

0.00

Quality Control

30 PD 12-06-29

140 Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish Memo

0.00

Hand Finishing

30 NG 12-7-3

150 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

150

Powdercoat Memo

0.00

Powder Coating

Mask inside of 0.8120" diameter hole START TIME: 11:40
OVEN TEMPERATURE: 320°F FINISH TIME: 12:10

30X M-F 12/07/04

m121841

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Page 3

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Item Name: Clamp

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30

Cust Item ID:

Required Date: 15/05/2012 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00				30	0		BL 1274
Quality Control									
170		0.00							
170	Small Fab								
Small Fab	Memo	0.00				30	0		FF 12-07-04
Small Fab	1- Press D2611 bearing into lug as per Dwg D3041 using DT 9472								
	2- Stake bearing into place as per Dwg D3041 using DT9456								
	3-Touch up stake marks with white emeron paint								
180	QC5- Inspect part completeness to step on W/O	0.00							
180									
QC	Memo	0.00							
Quality Control									

QC 21

ML5 12-10-19

count
430

MLF 12-10-29

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

May-01-12 10:37:23 AM

Page 1

Work Order ID: 84001

84001

Parent Item: D3041-3

D3041-3

Parent Item Name: Clamp

Start Date: 01/05/2012

Required Date: 15/05/2012

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP: A01.07.11New IssueSM/EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2611		Manufactured	No			100	Each	29.0000	1	30			

D2611

Bearing

**

(30) FF 12-07-07

Location

ST012

84434
86264
79867

Loc Qty

29

29

Loc Code

19

D2423

Manufactured No

170

f

546.5580

0.1042

3.290526

**

D2423

Lug Extrusion

Location

MAT006

43722

68331

81557

Loc Qty

546.558

161.5

81.058

304

Loc Code

MF 12-07-06

D 3041-3P

X 30

6/4/12 (30)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DART AEROSPACE LTD		Work Order: 84001
Description: Clamp		Part Number: D3041-3
Inspection Dwg: D3041	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.20	+/-0.030					
0.240	+/-0.010					
R1.190	+/-0.010					
0.400	+/-0.010					
R0.250	+/-0.010					
0.313	+/-0.010					
R0.063	+/-0.010					
1.19	+/-0.030					
1.124	+/-0.010					
0.563	+/-0.010					
R0.562	+/-0.010					
Ø0.8115 - 0.8110	N/A					
2.071	+/-0.010					
0.750	+/-0.010					
0.375	+/-0.010					
R0.338	+/-0.010					
3.450	+/-0.010					
Ø0.257	+0.005-0.000					
R0.375	+/-0.010					
0.375	+/-0.010					
R0.032	+/-0.010					
R0.250	+/-0.010					

N/A
 was subcontracted out
 there per Memo
 12/7/0

Measured by:	Audited by:	Prototype Approval:	N/A
Date:	Date:	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.05.04	New Issue	KJ/DD	

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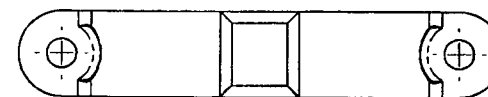
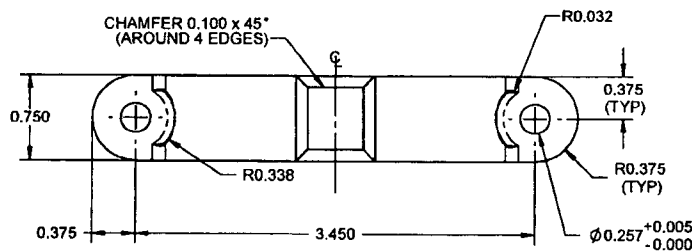
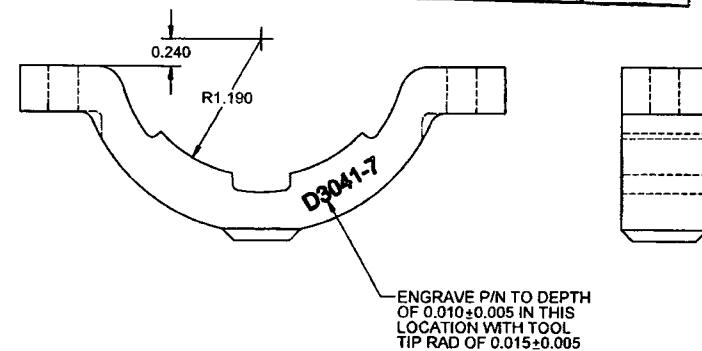
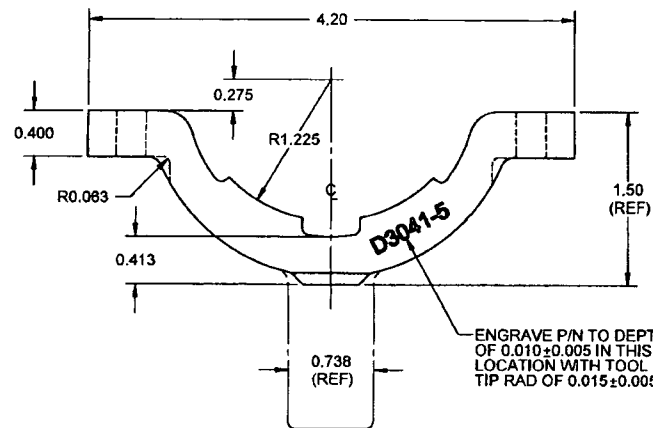
NOTE: Date & initial all entries

84001

DEO ATTACHE

RELEASED

06.11.17

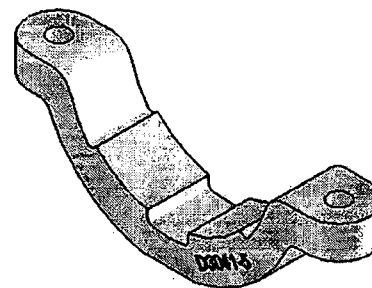


D3041-5 CLAMP

D3041-7 CLAMP
(SAME AS D3041-5
EXCEPT AS SHOWN)

NOTES:

- 1) MATERIAL: MANUFACTURE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS 0.010 TO 0.020
- 6) PART IS SYMMETRIC ABOUT ϕ



DESIGN 97	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3041	REV. C SHEET 2 OF 2
DATE 06.10.18	TITLE CLAMP	SCALE 1:1	
COPYRIGHT © 2001 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

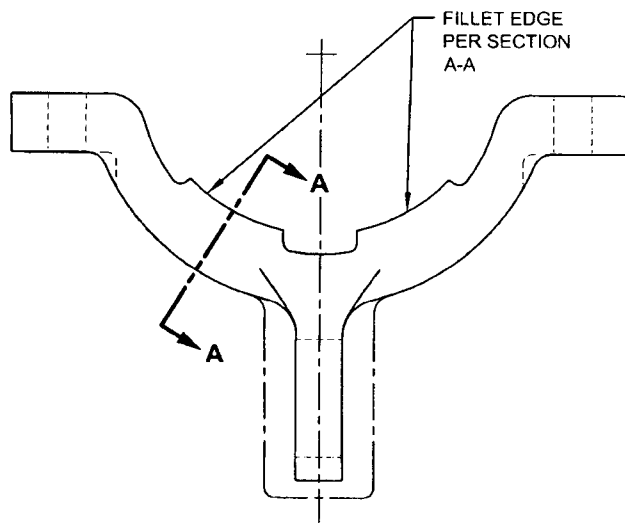
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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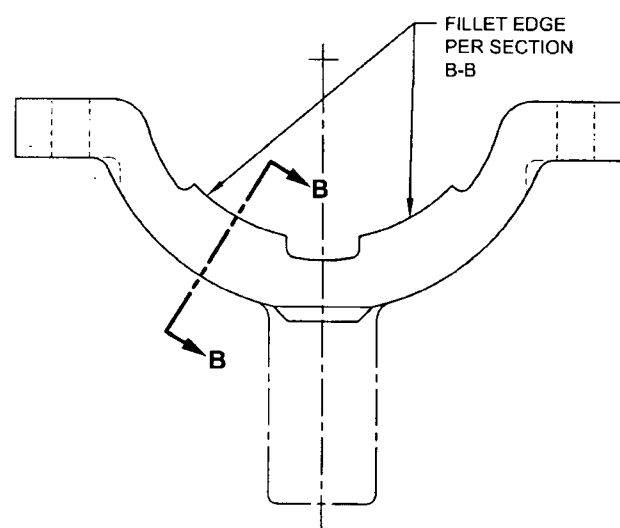
DRAWING NO. D3041	TITLE CLAMP	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3041-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN ADS	CHECKED	MFG. APPR.	APPROVED		DE APPR.		
DATE 09.03.04	DATE 09.03.12	DATE 09.03.12	DATE 09.03.13		DATE 09.03.13		

ADD FILLETS TO -1/-3/-5/-7 PER SECTIONS A-A AND B-B TO PREVENT CHAFING OF RUBBER CUSHIONS AS SHOWN:



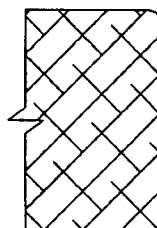
D3041-1 CLAMP

D3041-3 CLAMP



D3041-5 CLAMP

D3041-7 CLAMP



R0.060 MIN - R0.10 MAX
2PL

SECTION A-A

SCALE 2X

SECTION B-B

SCALE 2X

SEE PAR 122 FOR FURTHER DETAILS

RELEASED
09/07/07

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 18568
Date: Jun 27, 2012
Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 16878	Sold By: Dewar, Eric
Shipped By: your truck	Ship Date: Jun 27, 2012

Description		Unit	Ordered quantity	Shipped quantity	Backorder quantity
D3041-1	Clamp as per dwg D3041 Rev.C B8400	Each	30		
D3041-3	Clamp as per dwg D3041 Rev.C B84001	Each	30	30	
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.					
Received by _____			Thank you for your order!		



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0
Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
30	D3041-3	Clamp	16878

MATERIAL: supplied by DART B81557

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

A handwritten signature in black ink, appearing to read "Jan Norris".

Jan Norris

Vankleek Hill, June 27, 2012



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO16878

Purchase Order Date 5/2/2012

PO Print Date 5/2/2012

Page Number 1 of 1

Order From :

VC-MET003

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, ON K0B 1R0
CA

Contact Name		Buyer	Brigitte Golden
Vendor Phone	613 678 3957	Requisition Nbr	
Vendor Fax	613 678 3956	Tax Resale Nbr	10127-2607
Vendor Account Nbr		Terms	Net 30
		Currency	CAD
		FOB	Destination-Collect

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAXED
6/2/12

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D3041-1P	Clamp	5/15/2012 Yes	30.00 Each	Dart Truck	\$42.0000	\$1,260.00
		Special Inst:	AS PER DWG: D3041 REV: C B8400				
2	D3041-3P	CLAMP	5/15/2012 Yes	30.00 Each	Dart Truck	\$42.0000	\$1,260.00
		Special Inst:	SAME AS ABOVE B84001				

PO Total: \$2,520.00

Change Nbr: 1

Change Date: 5/2/2012

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

